

5021523



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D4634-141

Job Sheet 167074-A



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	17/12/14
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	17/12/14
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	17/12/14
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	17/12/14
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	17/12/14
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	17/12/14

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/29 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-1 <u>5021456</u>	1	3 <u>5019743</u>	0	0
	ST 107- D4636-5 <u>5021455</u>	1	43	0	0
	- D4647-5 <u>5021453</u>	1	2	0	0
	- D4664-5 <u>5021452</u>	6	39	0	0
	- D4712-1 <u>5021451</u>	1	4	0	0
	- D4732-15 <u>5157453</u>	1	2	0	0
	- D4732-19 <u>5021447</u>	1	1	0	0
	- D5021-1 <u>5021444</u>	1	2	0	0
	- MPNY-750S-9-C <u>5021443</u>	7	570	0	0
	- MS20426AD3-4 <u>5021441</u>	4	5,055	0	0
	- MS20426AD4-6 <u>5021440</u>	2	2,797	0	0
	- MS21059L08 <u>5021439</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION _____		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Mfg Date: 12/13/17 Job No: 167074-A		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____				Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
Date: _____				Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
				Large Fab ☐	Composite ☐	Supplier ☐	
				QTY Effective: _____		MRB (QSI042) Approval	
				Disposition		Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Environment ☐		PART NO: D4634 - 141		FAULT CATEGORY			
Design ☐		Revision: _____		Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Doc/Data ☐		Operation: _____		Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Equip/Tooling ☐		Change No: _____		BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Handling/Pre ☐				Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Material ☐				Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Internal Transport ☐				Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Tribal Knowledge ☐				Countersink ☐	Off-set ☐	Drawing ☐	
LOA ☐				Cut Too Short ☐	Mislabeled ☐	Finish ☐	
Substation ☐				Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Past Expiry Date ☐				Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Misidentified ☐							
		OTHER: _____					